

Work Order ID 51505

August 25, 2009 1:34:01 PM



Page 1

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 8/24/09 Start Qty: 1.00

Required Date: 8/24/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

PL WY

Date: *08-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP
9-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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QC:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

SAP 00910-05

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 or 10/05

HL

φ

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Run Start



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Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004.
A/R [] Aluminum Rod

MILL 979

BE 09/09/07

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R [] Aluminum Rod

MILL 979

BE 09/09/07

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

A.m 09-10-13 ①

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

A.m 09-10-13 ①

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

A.m 09-10-13 ①

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

A.m 09-10-13 ①

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

A.m 09-10-13 ①

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

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Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

27 8/21/13

0.00

(XO)

✓

QC

Memo

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

27 8/21/13

0.00

(XO)

✓

QC

Memo

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

27 8/21/13

0.00

(YI)

✓

HandFinish

Memo

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Date:

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Date:

Run Start

QC:

Date:

SPC (Y/N):

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Stop

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45pm
320°F
2:15pm

0.00

Powder Coating

190

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

M112260

=> Jcl 09/10/13 (X1) 0

BK 09-10-14

0.

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

X1

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291
Sikaflex expire date: 10/26 m112391

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 m112391
Sikaflex expire date: 10/26

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: m112106

MD 09/10/14

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Cust Item ID:

Required Date: 8/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

2) 8/24/09

70

6

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: PPP 51492

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09/10/23 ①

09/10/23
MF 09-10-23

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Page 1

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Work Order ID: 51505

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	14.0000	1.0000			



205 Skidtube bent detail



B51742
DP 9-9-29

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

13

50757

3

50761

6

50976

2

50977

2

Main Warehouse

ST

1

50758

1

D2576-3RevG

Manufactured No

140

Each

141.0000

1.0000



Step (maching detail)



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

141

43504

40

46661

101

1
BE 09/09/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 51505

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	464.0000	20.0000			



Crossbolt Spacer



SAP 09/10/05

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	B# 51525	X20
ST	464	
43988	4	
46434	4	
46956	2	
47797	9	
48272	22	
51314	100	
51315	323	

D2855RevA

Manufactured No

~~B# 51525~~

200

Each

29.0000

1.0000



Cap



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	50770	
FP	-1	
50513	-1	
Main Warehouse		
FP6	31	
50513	31	
Main Warehouse		
ST	-1	
50513	-1	

XL m009/10/14

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Page 2

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Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			200	Each	2,515.000	2.0000			
Bolt												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2515

100188

212

105057

2245

15205

58

X2 MD 09110114

AN960JD10L

Purchased

No

200

Each

6,679.000

2.0000



Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

-2

109632

-2

Main Warehouse

ST

6681

101291

16

104885

153

105793

236

109632

1276

110985

5000

X2 MD 09110114

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ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105855

108606

111529

111779

3628

16

52

1560

2000

200

Each

632.0000

50.0000



X50

MO 09/10/11

AN3C4A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

112314

Main Warehouse

ST

112082

112314

50

-50

682

30

652

112724

112720

X12

X38

MO 09/10/14

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AN960C10L  washer		Purchased	No			200	Each	2,946.000	50.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

103585

Main Warehouse

FP

112116

Main Warehouse

ST

112116

D3566-13RevC

Manufactured

No

200

Each

20.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

48166

Main Warehouse

ST

45717

46889

48166

50265

-1

-1

21

1

1

3

16

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D3566-5RevC		Manufactured	No			200	Each	17.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

-1

51260

-1

Main Warehouse

ST

18

36113

1

46186

1

47318

1

48167

1

51260

14

D3566-1RevC

Manufactured

No

200

Each

27.0000

2.0000

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

-2

51259

-2

Main Warehouse

ST

29

46349

1

47434

2

51218

1

51259

25

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D3564-11RevD		Manufactured	No			200	Each	29.0000	1.0000			



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	22	
51256	22	
Main Warehouse		
FP19	-1	
50112	-1	
Main Warehouse		
ST	8	
45823	1	
50112	7	

51594

XL MD 09/10/14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:01 PM

Page 8

Work Order ID: 51505

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	30.0000	1.0000			



Wearshoe



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	52639	
FP17	17	
50270	17	
Main Warehouse		
FP19	-1	
50270	-1	
Main Warehouse		
ST	14	
45409	3	
46495	10	
47867	1	

X1 m009110/14

August 25, 2009 1:34:01 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:01 PM

Page 9

Work Order ID: 51505

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	20.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

51258

Main Warehouse

ST

44659

45825

51258

-2

-2

22

1

1

20

XL MD 09/10/14

D3564-5RevD

Manufactured No

200

Each

17.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

34806

Main Warehouse

FP19

48555

51257

2

2

15

1

14

XL MD 09/10/14

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Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:01 PM

Work Order ID: 51505

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	542.0000	16.0000			
												
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27168

29908

542

44

498

51613

200

Each

348.0000

16.0000

X16 MD 09/10/14

D2594-1RevC

Manufactured

No



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

42221

42807

43884

46435

47251

348

16

92

3

2

235

5757

X16 MD 09/10/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

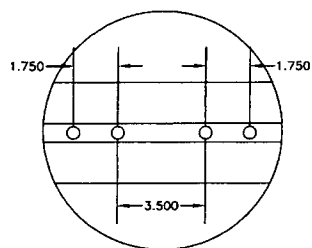
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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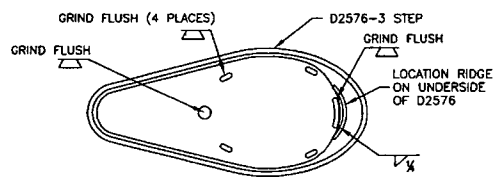
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DETAIL E
SCALE 5:24

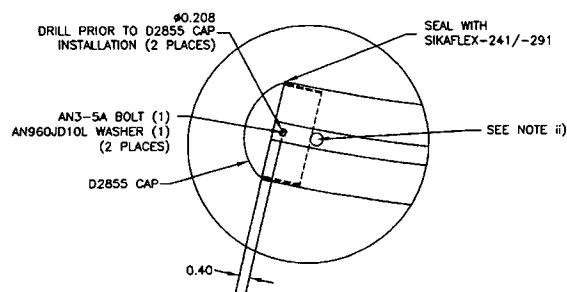


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07 Dec 28

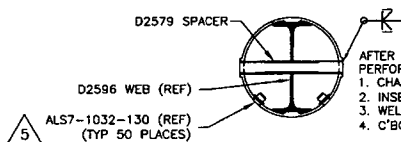
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

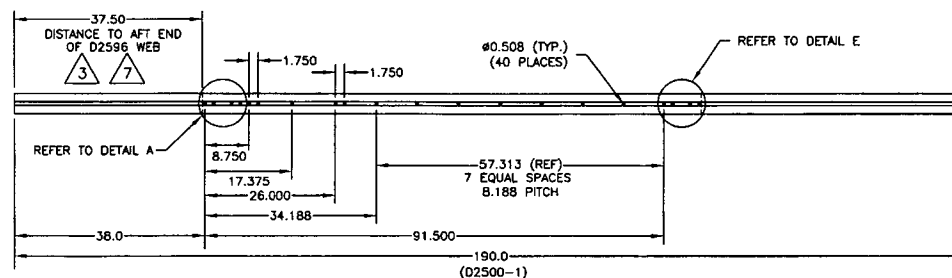


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

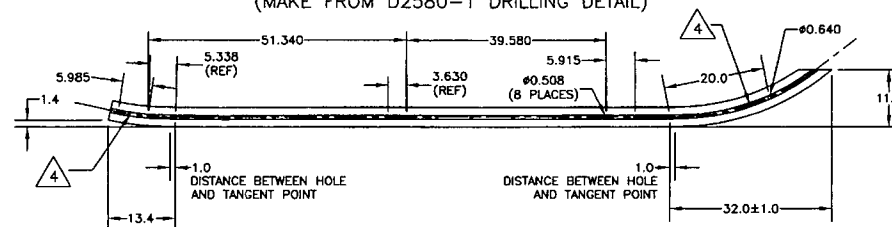
D2580-04.5 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

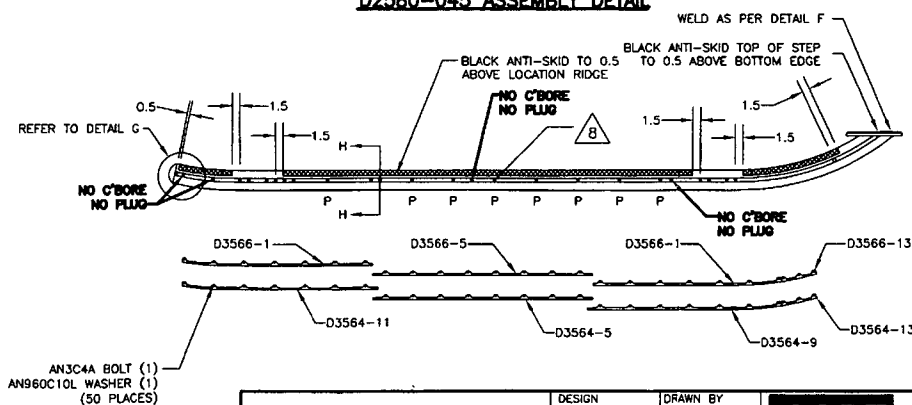
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN

P4

CHECKED *lsl*

17

DATE _____

07 02 27

DRAWN BY

P

APPROVED

1

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO

02580

TITLE

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 3 OF 3

SCALE

1:24

NO. 212

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 51505
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rob Dint Date of Test Coupon 09.10.09
Welder Barday Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld